

Work Order ID 77172

77172

Page 1

November-28-11 9:01:20 AM

Item ID: D412-704-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pedal Assembly (205/212/214/412)
 Start Date: 28/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/12/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 11/11/28 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D412-704-041	Rev A

100 Small Fab 0.00
100
 Small Fab Memo 0.00
 Small Fab Assemble pedal as per Dwg D412-704-041
 Tighten & Torque Bolts as per Dwg D412-704-041

[Handwritten signature] 11/12/06 (V)

110 QC5- Inspect part completeness to step on W/O 0.00
110
 QC Memo 0.00
 Quality Control

[Handwritten signature] 11/12/06

(40)

120 Pick Kit 0.00
120
 Packaging Memo 0.00
 Packaging

[Handwritten signature] 11/12/06 (U)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77172***77172***

Page 2

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Item ID: D412-704-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pedal Assembly (205/212/214/412)

Start Date: 28/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC4- 100% Inspect kits for completeness 0.00

130

QC Memo 0.00

Quality Control

140 Identify as per dwg & Stock Location: 191 0.00***140***

Packaging Memo 0.00

Packaging

150 QC21- Final Inspection - Work Order Release 0.00

150

QC Memo 0.00

Quality Control

mf
11-12-07

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Picklist Print

November-28-11 9:01:25 AM

Page 1

Work Order ID: 77172

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B05.01.28Removed hardware on Step 2; Added Figures 1-3KJ/RF
IPP Rev:C06.03.08 Re-format EC
IPP Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20 JLM
IPP Rev:E 07.05.02 Reformat EC
IPP Rev:F 08-10-08 as per revB DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-10A *AN3-10A* Bolt		Purchased	No			100	Each	138.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				95					
				119084				95					
				ST351				43					
				117795				27					
				119128				16					
AN315-4R *AN315-4R* Nut		Purchased	No			100	Each	40.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST324				40					
				17566				40					
AN4-10A *AN4-10A* Bolt		Purchased	No			100	Each	125.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST356				125					
				117619				125					

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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November-28-11 9:01:25 AM

Page 2

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-12A Purchased No

100 Each 169.0000 2 2

AN4-12A

Bolt

**

EP 11/12/06

Location

Loc Qty

Loc Code

ST357

169

115422

4

117508

65

118628

100

2

AN4-13A Purchased No

100 Each 953.0000 1 1

AN4-13A

Bolt

**

EP 11/12/06

Location

Loc Qty

Loc Code

ST357

953

118078

17

118838

436

119449

500

1

AN960JD10 NAS1149D0363J Purchased No

100 Each 0.0000 5 5

AN960.ID10

Washer

4 M117601 (34)

**

EP 11/12/06

AN960JD416 NAS1149D0463J Purchased No

100 Each 0.0000 11 11

AN960.ID416

Washer

4 M115075 (112)

**

EP 11/12/06

AN960JD416L NAS1149D0416J Purchased No

100 Each 11.0000 3 3

*AN960.ID416I *

Washer

**

EP 11/12/06

Location

Loc Qty

Loc Code

FP

11

110153

11

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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November-28-11 9:01:25 AM

Page 3

Work Order ID: 77172

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3204-041 Manufactured No

100 Each

1.0000

1 1

D3204-041

Release Pedal Assembly

**

Location

Loc Qty

Loc Code

GA

1

68570

1

D3205-1 Manufactured No

100 Each

1.0000

1 1

D3205-1

Pedal Bracket

**

Location

Loc Qty

Loc Code

GA

1

71652

1

D3205-3 Manufactured No

100 Each

18.0000

1 1

D3205-3

Back Plate

**

Location

Loc Qty

Loc Code

GA

18

69626

8

70285

10

D3206-1 Manufactured No

100 Each

16.0000

1 1

D3206-1

Pedal Arm

**

Location

Loc Qty

Loc Code

GA

16

73469

16

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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November-28-11 9:01:25 AM

Page 4

Work Order ID: 77172

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3209-041

Manufactured No

100

Each

10.0000

1

1

D3209-041

Bracket Assembly

**

EP 11/12/06

Location

Loc Qty

Loc Code

GA

10

71653

10

MS21042L3

Purchased No

100

Each

7,957.000

1

1

MS21042L3

Nut

**

EP 11/12/06

Location

Loc Qty

Loc Code

ST300

213

117441

16

117885

35

118451

5

118927

157

ST516

5994

119017

5994

ST518

1750

119075

1750

MS21042L4

Purchased No

100

Each

10,709.00

5

5

MS21042L4

Nut

**

EP 11/12/06

Location

Loc Qty

Loc Code

ST300

546

117441

51

117601

362

118451

133

ST516

5163

119017

5163

ST518

5000

119075

5000

November-28-11 9:01:25 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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November-28-11 9:01:25 AM

Page 5

Work Order ID: 77172

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

MS24694-S102

Purchased

No

100

Each

35.0000

1

1

MS24694-S102

Screw

**

EP 11/12/06

Location

Loc Qty

Loc Code

ST289A

35

114382

35

MS9519-10

Purchased

No

100

Each

23.0000

1

1

MS9519-10

Bolt

**

EP 11/12/06

Location

Loc Qty

Loc Code

ST296

23

100290

23

AN3-6A

Purchased

No

120

Each

164.0000

2

2

AN3-6A

Bolt

**

EP

Location

Loc Qty

Loc Code

ST351

164

117441

164

AN960JD10L

NAS1149D0332J

Purchased

No

120

Each

0.0000

4

4

AN960.ID10I

Washer

**

117441
118384 (04/12/11)

November-28-11 9:01:25 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
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Page 6

Work Order ID: 77172

77172

Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

120

Each

7,957.000

2

2

MS21042L3

Nut

**

Lo 11/12/11

Location

Loc Qty

Loc Code

ST300

213

117441

16

117885

35

118451

5

118927

157

ST516

5994

119017

5994

ST518

1750

119075

1750

119075

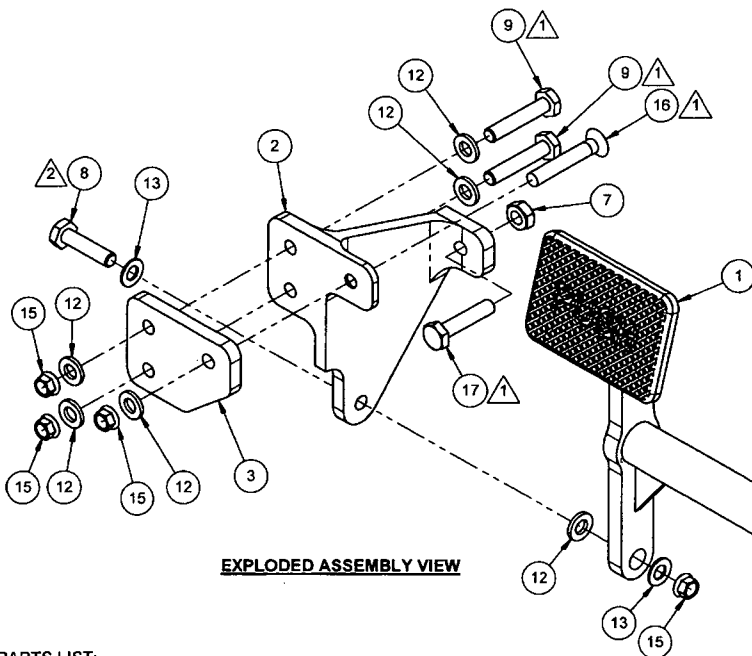
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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EXPLODED ASSEMBLY VIEW

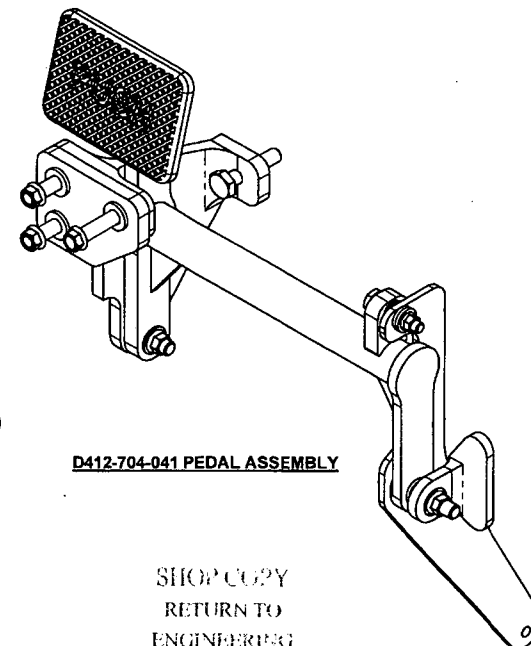
PARTS LIST:

ITEM	QTY	P/N	DESCRIPTION
-	X	D412-704-041	PEDAL ASSEMBLY
1	1	D3204-041	PEDAL WELDMENT
2	1	D3205-1	PEDAL BRACKET
3	1	D3205-3	BACK PLATE
4	1	D3206-1	PEDAL ARM
5	1	D3209-041	BRACKET ASSEMBLY
6	1	AN3-10A	BOLT
7	1	AN315-4R	NUT
8	1	AN4-10A	BOLT
9	2	AN4-12A	BOLT
10	1	AN4-13A	BOLT
11	5	AN960JD10	WASHER
12	11	AN960JD416	WASHER
13	3	AN960JD416L	WASHER
14	1	MS21042L3	NUT (OR MS21042-3)
15	5	MS21042L4	NUT (OR MS21042-4)
16	1	MS24694-S102	SCREW
17	1	MS9519-10	BOLT
N/A*	2	AN3-6A	BOLT
N/A*	4	AN960JD10L	WASHER
N/A*	2	MS21042L3	NUT (OR MS21042-3)

* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)

NOTES:

- 1 INSTALL IDENTIFIED FASTENERS LOOSE (HAND TIGHTEN ONLY).
- 2 TIGHTEN IDENTIFIED FASTENERS UNTIL SNUG. ENSURE THAT PARTS CAN STILL ROTATE.
- 3 TORQUE IDENTIFIED FASTENERS TO 15-25 in-lbs (1.7-2.8 N-m).



D412-704-041 PEDAL ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77-132-M-L-5

11/11/28

RELEASED

07.01.20

A	07.01.23	NEW ISSUE	
REV	DATE	DESCRIPTION	
DESIGN	DRAWN BY	DART AEROSPACE LTD	
C.B.	C.B.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
CE		D412-704-041	SHEET 1 OF 1
DATE	07.01.23	TITLE	SCALE
		PEDAL ASSEMBLY	1:2

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